

Work Order ID 117523

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117523 BH

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Item ID: D119-646-241 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)
 Start Date: 4/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/24/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-04-24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3887-045	C								
IIN-D119-646	B								

100 Document Control 0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-241

CHG003

JUN 16 2014

DAS
86
9-89

110

0.00

110

Skidtubes

Memo

0.00

Skidtubes

1- inspect Mat'L D2500-1-190 for damage

2-Cut tube to length as per dwg D3887 (154.8")

3- Ensure squareness of ends and scribe batch#



14-4-28

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120 HandFinish	Memo	0.00							
Hand Finishing									DAS 18 9-89
121	QC7-Inspect Chemical Conversion Coat	0.00							
121 QC	Memo	0.00							
Quality Control									DAS 18 9-89
122	QC5- Inspect part completeness to step on W/O	0.00							
122 QC	Memo	0.00							
Quality Control									DAS 18 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130		0.00							
Skidtubes	Memo								
Skidtubes	1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/RSikaflex-291 <u>128026</u> Sikaflex expire date: <u>14-10-09</u> Start: <u>1:15pm</u> Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours) *****								DGL 14-4-29

DGL 14-4-29

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Item ID: D119-646-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

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Start Date: 4/24/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/24/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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135

QC5- Inspect part completeness to step on W/O 0.00

135


QC

Memo

0.00

Quality Control

DAS
03
9-89

 144-30

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							

140

Skidtubes

Skidtubes

Memo

0.00

1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning***

2- Cut FWD end of tube as per dwg D3887.***Verify measurment***

3- Buff out marks left from bending

4- Drill FWD cap holes using DT8215. Do not open FWD & AFT cap holes to 0.208"

5- Open FWD saddle holes to finished size as per dwg D3887

6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement)

7- Drill Tow ring hole, using DT9494 locate from FWD cap hole. (verify neasurement). Open to finished size.

8- Drill 1.87" and 3.74 holes using DT9494 locate from FWD cap hole. (verify measurement) as per dwg DEO D3887-B-1.

9- Open FWD and Aft cap holes to finish size as per dwg.

10- C'sink FWD cap hole as per detail "C"

11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

12- Deburr and blow out chips from inside of tube.

DAS
10
9-89

DAS
10
9-89

10047

Saddle

10048 A+B Saddle

14-5-7

DL 14/05/21

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	<p>1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>M127763</u> <u>BE 14-05-22</u></p> <p>2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole.</p> <p>3-Counterbore x-bolt spacer holes as per Dwg D3887.</p> <p>4- C'sink FWD cap holes as per detail "C"</p> <p>5- Deburr and blow out chips from inside of tube</p> <p><u>DE 14/05/22</u></p>								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

4/15/26

DL 14/05/22

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 DAS 27 9-89 4/5/26							
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	24-5-27		
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:44 OVEN TEMPERATURE: 320 FINISH TIME: 3:14	0.00 0.00				24	14-06-13	(x1)	

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Item ID: D119-646-241 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

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Start Date: 4/24/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 4/24/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Wing Walk as per dwg QSI005 4.4 Batch 1112839090								
255	HandFinish	0.00							
	Hand Finishing								
256	QC3- Inspect Part Finish	0.00							
256	QC	0.00							
	Quality Control								
260	Identify as per dwg & Stock Location: <i>Sho</i>	0.00							
260	Packaging	0.00							
	Packaging								

DAS
06
9-89

JUN 16 2014

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Item ID: D119-646-241 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 4/24/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270	QC21- Final Inspection - Work Order Release	0.00							
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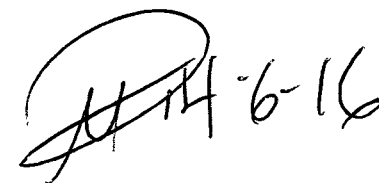
270

QC

Memo

0.00

Quality Control

MLJ 14-06-16

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Work Order ID: 117523

117523

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190		Manufactured	No			110	Each	42.0000	1	1			
D2500-1-190													
Ext'n -1" Beam Tube 4"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				42					
				105279				42					
D2579		Manufactured	No			140	Each	69.0000	2	2			
D2579													
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				69					
				113785				69					
D2855-3		Manufactured	No			240	Each	18.0000	2	2			
D2855-3													
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				18					
				111898				18					

**

**

**

14-4-28

BE-14-05-22

B117601 (2x) Ill w/loc 14

Picklist Print

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Work Order ID: 117523

117523

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

240

Each

1,222.000

2

2

D3672-1

Phenolic Washer

all 14/06/14

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1212

103845

4

112218

500

113581

500

93886

62

99099

146

✓ 2

D3681-1

Manufactured No

160

Each

204.0000

8

8

D3681-1

Spacer

BF 14-05-22

Location

Loc Qty

Loc Code

LG

148

114884

148

LG001

56

109109

56

8

D3849-041

Manufactured No

240

Each

1.0000

1

1

D3849-041

Fwd Wearplate Assy, Std/Float Gear

all 14/06/14

Location

Loc Qty

Loc Code

FP002

1

111006

1

13113742

✓ 1

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Work Order ID: 117523

117523

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

D3849-043

Manufactured No

240

Each

3.0000

1

1

D3849-043

Aft Wearplate Aay, Std Gear

**

ll 14/06/16

Location

Loc Qty

Loc Code

FP002

3

13113 573

102313

3

yl

D3885-1

Manufactured No

140

Each

15.0000

1

1

D3885-1

Standard Web

**

DBL 14-4-29

Location

Loc Qty

Loc Code

LG

11

111602

5

113847

6

LG002

4

102267

4

D3903-1

Manufactured No

160

Each

90.0000

12

12

D3903-1

Spacer

**

BEH-05-22

Location

Loc Qty

Loc Code

LG

2

112408

2

LG001

88

(13709)

88

D3904-1

Manufactured No

240

Each

436.0000

16

16

D3904-1

Washer

**

ll 14/06/16

Location

Loc Qty

Loc Code

ST068

436

113080

36

113662

400

ylle

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Work Order ID: 117523

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Parent Item: D119-646-241

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Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

240

Each

899.0000

2

2

AN3C5A

Bolt

all 14/06/14

Location

Loc Qty

Loc Code

FG

5

122800

5

M129198

v2

ST350

294

M128057

294

ST513

600

M128911

600

AN3C46A

Purchased

No

240

Each

314.0000

8

8

AN3C46A

Bolt

all 14/06/14

Location

Loc Qty

Loc Code

FG

10

122843

10

ST354

69

M127281

2

M128319

67

ST514

235

M128491

85

M128796

150

x8

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Work Order ID: 117523

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D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

240

Each

716.0000

8

8

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

40

124555

27

m126741

13

ST509

596

m128398

596

Each

150.0000

2

MS24694-C52

Purchased

No

MS24694-C52 ✓

SCREW

Location

Loc Qty

Loc Code

ST301

150

124308

50

m127059

100

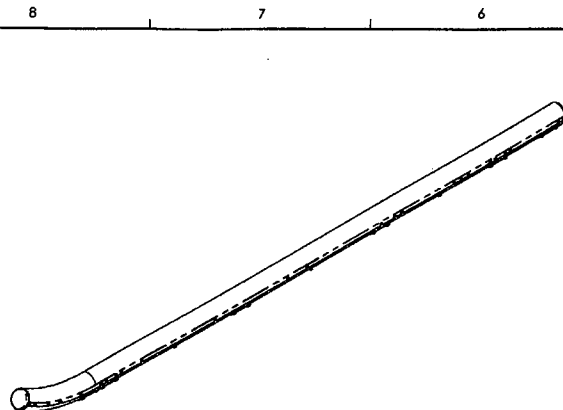
1126284

x 2

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D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs
D3887-043 = 37.0 lbs
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT
PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO $\phi 0.197$ HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL $\phi 0.297$ HOLES FOR WEARPLATE INSERTS.
INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5			D3846-1	GASKET
16	1			D3846-11	GASKET
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		ALS4-1032-130	INSERT
42	32	32	2	AN3C5A	BOLT
43			8	AN3C46A	BOLT
44	32	32		NAS1149C0332R	WASHER (OR AN960C10L)
45			8	MS21043-3	NUT
46	2	2	2	MS24694-C52	SCREW

RELEASED
 2013-03-19

117523 MLC
 14-04-24

C	(SMT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS (ZN C1-5, C1-6, B4-7) $\phi 0.201$ CSK $\phi 0.385 \times 100$ WAS $\phi 0.214$ THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1); ADD 134.04 (ZN C4-8), D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); $\phi 0.313$ WAS $\phi 0.328$ (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE 4 (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3887	SHEET 1 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3846-11
GASKET

D3847-11
WEARPAD

1.5 1.5 1.5

2.00 DISTANCE TO D3885-1 WEB, REF

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

1.5 1.5

AN3C5A BOLT
NAS1149C0332R WASHER
24 PL

PLUG UNUSED INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

D3846-1
GASKET
5 PL

D3847-1
WEARPAD
5 PL

D2855-3 CAP

1.5

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3887-11)

RELEASED
2013-03-19
mt

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3887	SHEET 2 OF 8
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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
8 PL

D3849-043
AFT TRAINING WEARPLATE ASSY

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

1.5

D3849-041
FWD TRAINING WEARPLATE ASSY

1.5

D2855-3 CAP

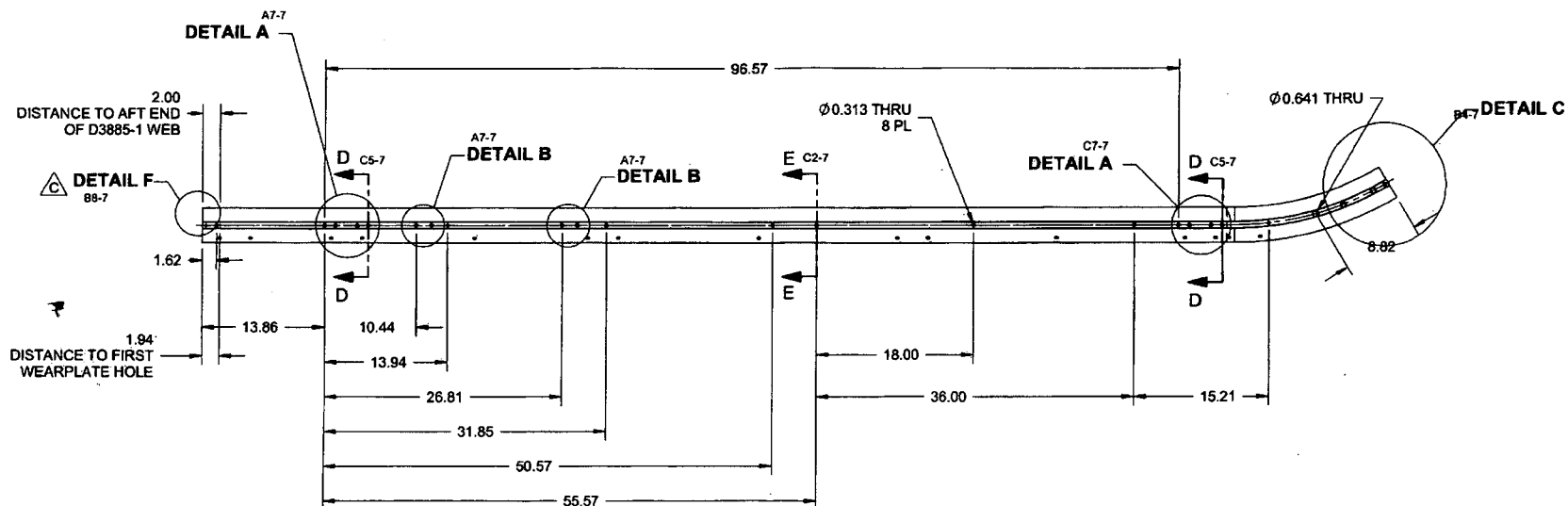
SEAL WITH
SIKAFLEX-241/291

MS24694-CS2 SCREW
(1 PER SIDE)

D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

RELEASED
2013-03-19

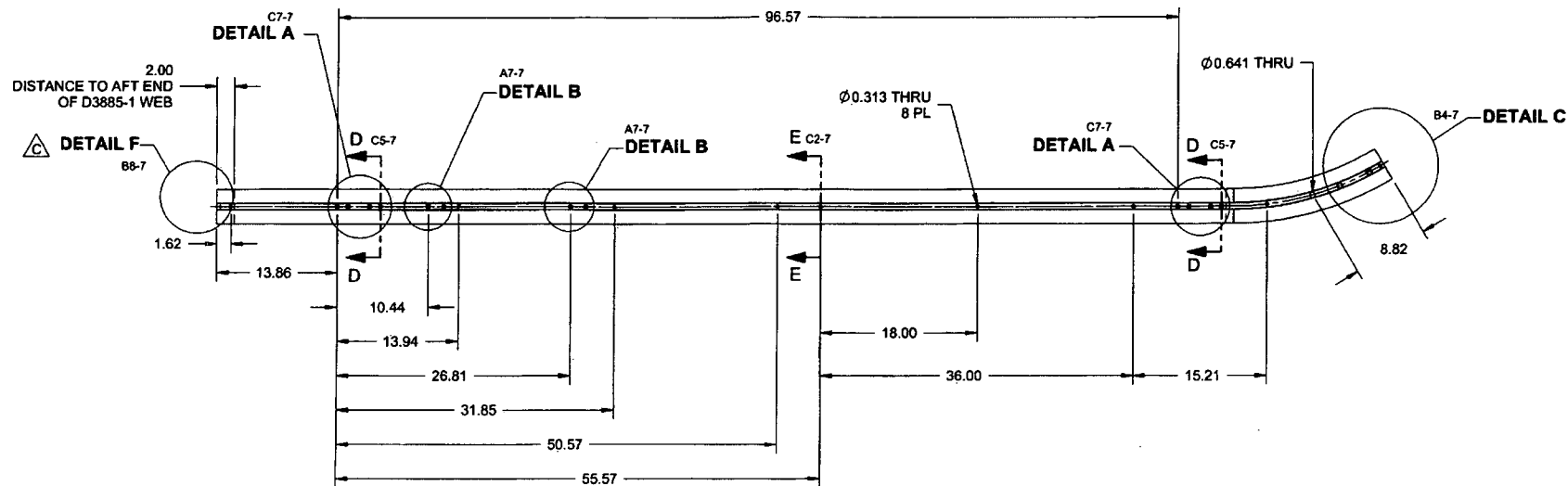
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MFG. APPR.	<i>AS</i>	D3887	SHEET 4 OF 8
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D3887-11 DRILLING DETAIL
(MAKE FROM D3887-1)

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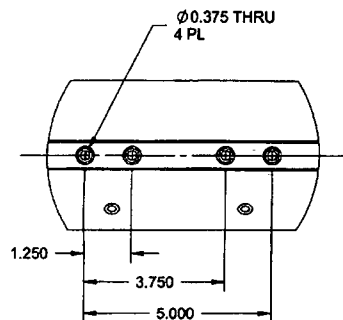
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MFG. APPR.	<i>DS</i>	D3887	SHEET 5 OF 8
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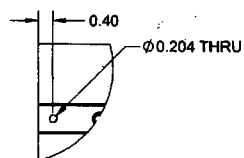
D3887-13 DRILLING DETAIL
(MAKE FROM D3887-1)

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2013-03-19

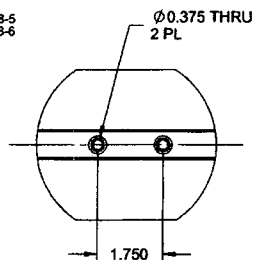
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MFG. APPR.	12	D3887	SHEET 6 OF 8
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DE APPR.	12	A119 STD SKIDTUBE ASSY	NTS
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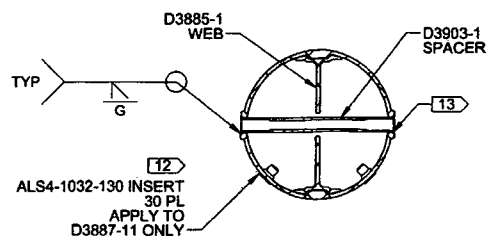
DETAIL A
SCALE 4X
D7-5
C3-5
D7-6
C3-6



DETAIL F
SCALE 4X
C8-5
C8-6

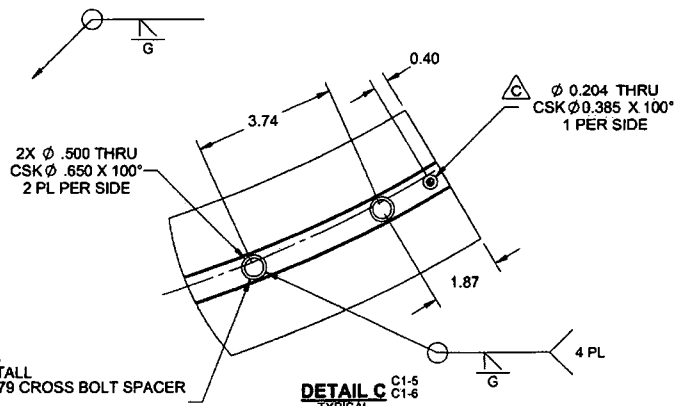


DETAIL B
SCALE 4X
C8-5
C5-5
C8-6
C5-6

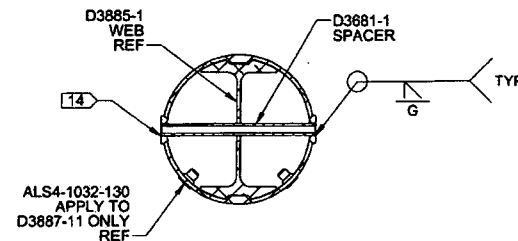


SECTION D-D
SCALE 4X
C7-5
C3-5
C7-6
C2-6

(FOR 12 X $\phi 0.375$ HOLES
PER SKIDTUBE)



DETAIL C
TYPICAL
SCALE 4X
C1-5
C1-6



SECTION E-E
SCALE 4X
C4-5
C4-6
(FOR 8 X $\phi 0.313$ HOLES
PER SKIDTUBE)

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:

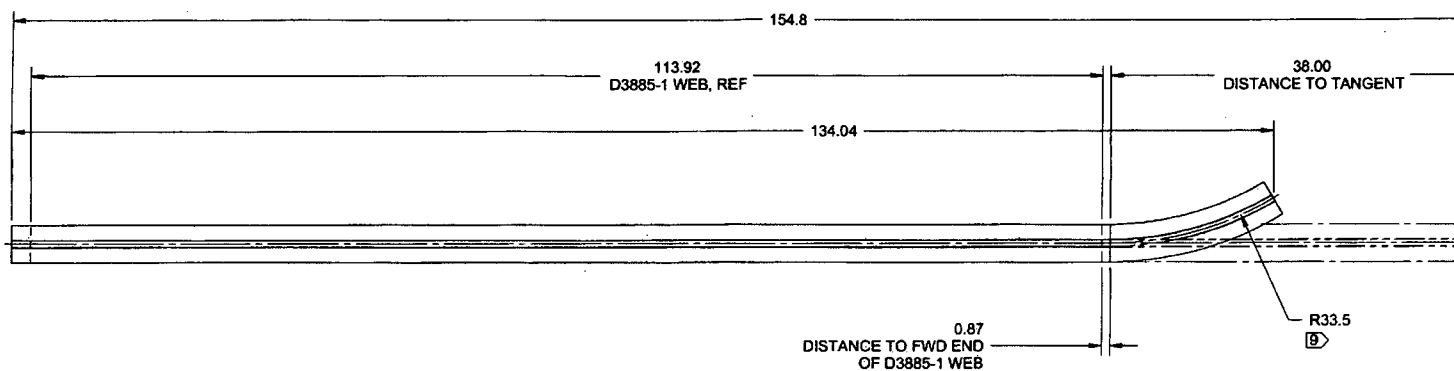
- i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
- ii) INSERT D3903-1 SPACER
- iii) WELD INTO PLACE AND GRIND FLUSH
- iv) C'BORE TO 0.313×0.75 DEEP
- v) DEBURR HOLES

14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.313$ HOLES ONLY:

- vi) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
- vii) INSERT D3681-1 SPACER
- viii) WELD INTO PLACE AND GRIND FLUSH
- ix) DEBURR HOLES

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2013-03-19

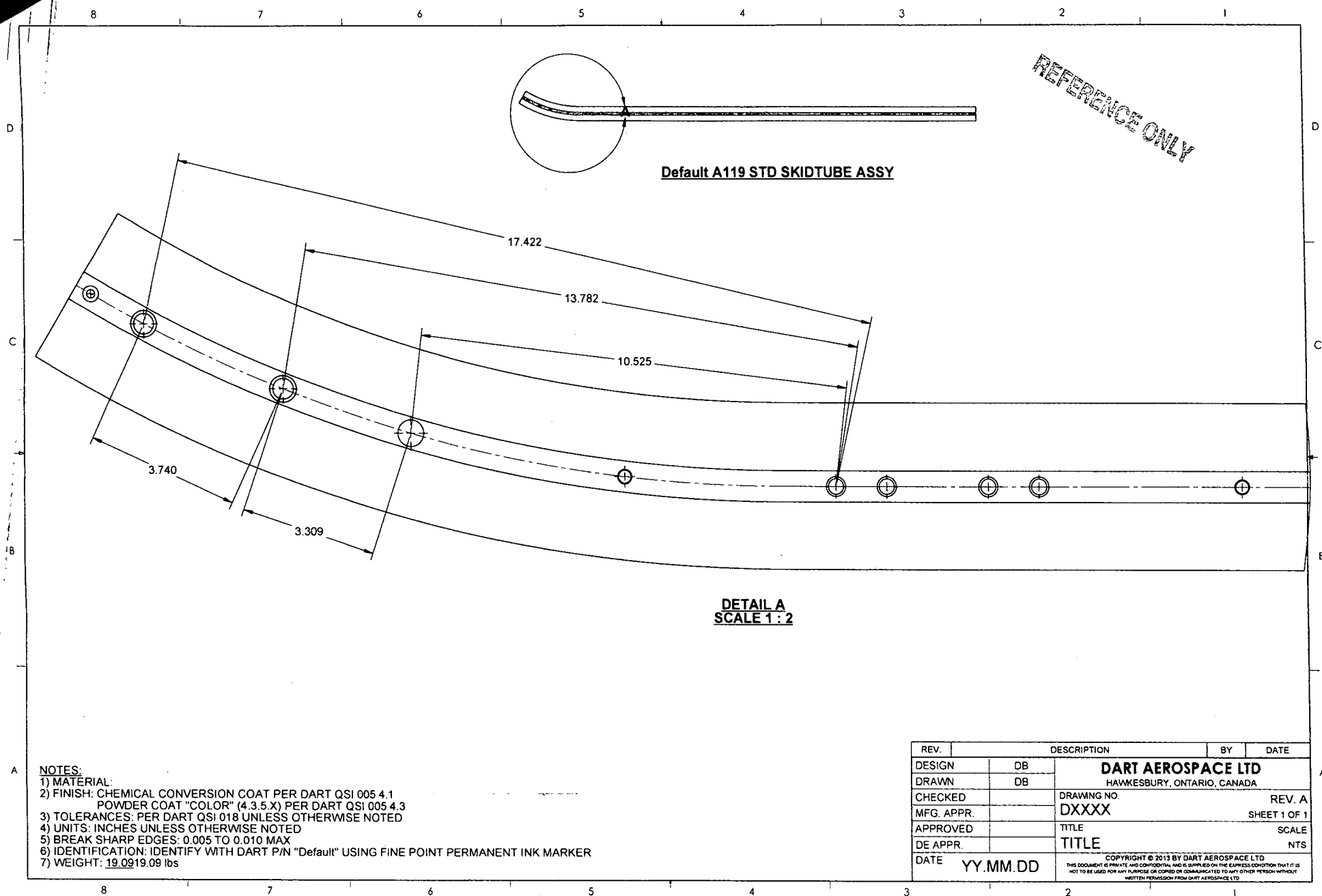
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DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3887	SHEET 7 OF 8
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D3887-1 BEND DETAIL
(MAKE FROM D2500-1-190 EXTRUSION)

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2013-03-19

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- NOTES:
- 1) MATERIAL: POWDER COAT "COLOR" (4.3.5 X) PER DART QSI 005 4.3
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "Default" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 19.0919.09 lbs

REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DXXXX	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		TITLE	NTS
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